

Date: Wednesday, 29/04/2009 3:07:51 PM
 User: Julie Dawson

Process Sheet

| | | | |
|-----------------------|--|------------------|----------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : INNER AFT SADDLE |
| Job Number | : 47633-1 | Part Number | : D5957 |
| Estimate Number | : 11082 | Drawing Number | : D5957 REVB |
| P.O. Number | : | Project Number | : N/A |
| This Issue | : 29/04/2009 S.O. No. : | Drawing Revision | : B |
| Prsht Rev. | : NC | Material | : |
| First Issue | : 1/1 Type : MACHINED PARTS | Due Date | : 15/05/2009 |
| Previous Run | : 43248 | Qty: | split 1 / 6 Um: Each |
| Written By | : | | |
| Checked & Approved By | : <u>JLD 09.04.29</u> | | |
| Comment | : Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------|---------------|
| 1.0 | D6101007 | Saddle Billet |
|-----|----------|---------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 D6101-007(7075-T7351)
 Size 2.50" x 7.50" X 8.25" (Grain along 7.50")
 Batch: 46412

| | | |
|-----|-------|--------------------------------|
| 2.0 | HAAS3 | HAAS CNC VERTICAL MACHINING #3 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

| | | |
|-----|-----|------------------------------|
| 3.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|



Comment: INSPECT ALL DIM TO DIM SHEET

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 47633

Part Number: D5957

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

2:15pm

OVEN TEMPERATURE:

320°C

FINISH TIME:

2:45pm

09/06/24 (SI)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 430

9/6/24

SI

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/25 (SI)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09/06/24

| | | |
|--------------------------------------|---------------|---------------------------|
| DART AEROSPACE LTD | | Work Order: 471033 |
| Description: Inner Aft Saddle | | Part Number: D5957 |
| Inspection Dwg: D5957 | Rev: B | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|---|---|---|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | | 0.439 | | | | | |
| B | 1.745 | 1.755 | | 1.750 | | | | | |
| C | 5.245 | 5.255 | | 5.250 | | | | | |
| D | 6.995 | 7.005 | | 7.000 | | | | | |
| E | 5.240 | 5.260 | | 5.250 | | | | | |
| F | 4.745 | 4.755 | | 4.750 | | | | | |
| G | 0.315 | 0.322 | | 0.321 | | | | | |
| H | 1.522 | 1.532 | | 1.527 | | | | | |
| I | 3.048 | 3.058 | | 3.053 | | | | | |
| J | 4.575 | 4.585 | | 4.580 | | | | | |
| K | 0.315 | 0.322 | | 0.321 | | | | | |
| L | 0.495 | 0.505 | | 0.498 | | | | | |
| M | 0.490 | 0.510 | | 0.499 | | | | | |
| N | 1.865 | 1.885 | | 1.885 | | | | | |
| O | 7.990 | 8.010 | | 8.001 | | | | | |
| P | 2.240 | 2.260 | | 2.252 | | | | | |
| Q | 0.307 | 0.312 | | 0.311 | | | | | |
| R | 0.760 | 0.765 | | 0.760 | | | | | |
| S | 0.490 | 0.510 | | 0.496 | | | | | |
| T | 1.625 | 1.645 | | 1.627 | | | | | |
| U | 2.000 | 2.020 | | 2.000 | | | | | |
| V | 0.023 | 0.043 | | 0.033 | | | | | |
| W | | | | | | | | | |
| X | | | | | | | | | |
| Y | | | | | | | | | |
| Z | | | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

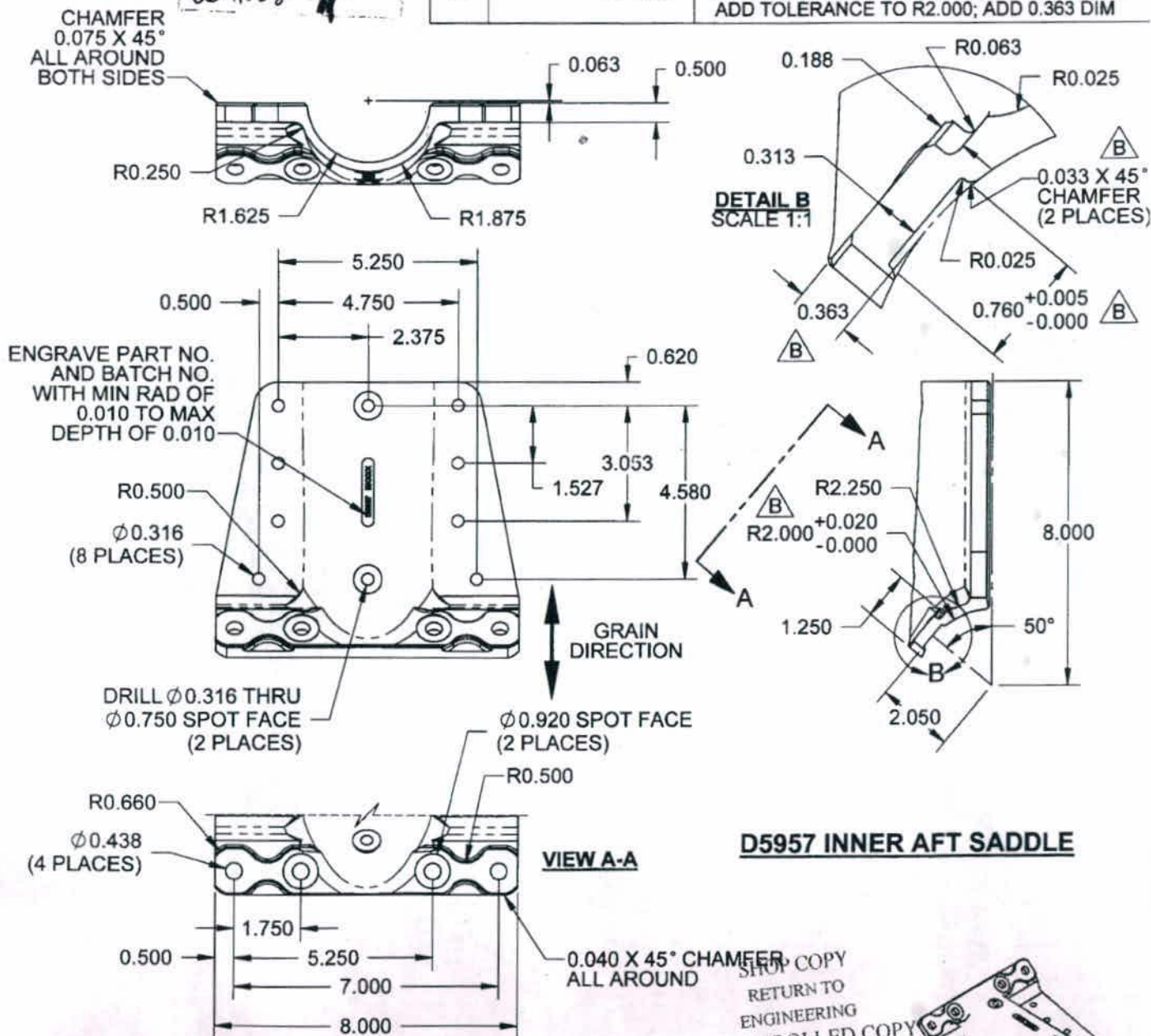
| | |
|--------------|----|
| Measured by: | JL |
| Date: | |

| | |
|-------------|----------|
| Audited by: | SP |
| Date: | 09/06/24 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | 99.04.19 | New Issue | RF | |
| B | 02.12.13 | Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B | KJ/RF | |
| C | 06.11.20 | Added dimension V | KJ/JLM | |
| D | 06.12.06 | Dimensions L,N,P revised | KJ/EC | |
| E | 07.06.15 | Dimension G revised | KJ/JLM | |
| F | 08.04.21 | Dimension E revised | KJ/DD | |
| G | 08.09.05 | Dimension K revised | KJ/DD | |



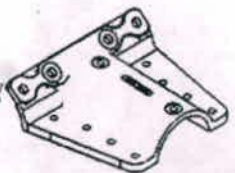
| | | |
|-------------------------|----------------------------------|---|
| DESIGN BW | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED LE | APPROVED [Signature] | DRAWING NO. D5957 |
| DATE 06.11.07 | TITLE INNER AFT SADDLE | REV. SHEET 1 OF SCAL 1: |
| REV A | DATE 97.05.06 | DESCRIPTION NEW ISSUE |
| B | 06.11.07 | INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM |



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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BY 11033



ISOMETRIC VIEW
SCALE 1:8

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